

Ships April 24th



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SOLD

D4038-4

Job Sheet 174521



Part No: D4038-4

Job Qty: 2 ea

Part Name: Angle, Aft, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/16/18

Job Tracking No:

Due Date: 4/9/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D4038 REV.F SHEET 6 Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC IPP REV:B 18.02.08 AS
PER DWG REV.F DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	4/9/18	4/9/18	0.00	0.00	Start Up Machining-2		SMC 18/04/18
100	Bandsaw	2 pcs	4/9/18	4/9/18	0.00	0.14	Bandsaw1		"
110	CNC Vertical Machining	2 pcs	4/9/18	4/9/18	0.00	2.15	HAAS1-4		"
120	QC	2 pcs	4/9/18	4/9/18	0.00	0.00	QC2 Machining-2		"
130	QC	2 pcs	4/9/18	4/9/18	0.00	0.00	QC8 Machining-2		SMC 18/04/24
140	HandFinish	2 pcs	4/9/18	4/9/18	0.00	0.14	HandFinish1		SA 18/04/25
150	QC	2 pcs	4/9/18	4/9/18	0.00	0.00	QC3		11 APR 25 2018
160	Packaging	2 pcs	4/9/18	4/9/18	0.00	0.00	Packaging3-2		8-89
170	QC21-SA	2 Ea	4/9/18	4/9/18	0.00	0.00	QC21		APR 25 2018

Part Op 100 - Cut Blank 7.625" long

Descriptions: 110 - Mill as per Dwg & Folio FA880 Dwg Rev: _____ Folio Rev: _____ Debur

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location: _____

170 - QC21- Final Inspection - Work Order Release

21
9-89

APR 25 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6A4.000W.250	6061T6 Angle 4.00 X 4.00 X .250	1.4000 ft (.7 ea)	90-Start up Operation	

ations

Required	Inventory	Allocated
1	6	0

ications

id not be found.



Container No: S063632



Part: D4038-4

Job No: 174521

Serial No/Batch: S063632

Revision: F
Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/21/18

Plex 3/16/18 2:21 PM Dart.Gagnon.Michelle

DART AEROSPACE LTD		Work Order:	174521
Description: Angle, Aft, RH		Part Number:	D4038-4
Inspection Dwg: D4038	Rev: E/F 4 9-89	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	3.990	✓		vern	mmL-05
1.250	+/-0.010	1.247	✓			
1.25	+/-0.030	1.250	✓			
4.00	+/-0.030	3.992	✓			
0.250	+/-0.010	0.245	✓			
R0.25	+/-0.030	0.25	✓		RG	
0.581	+/-0.010	0.578	✓		vern	mmL-05
0.669	+/-0.010	0.669	✓		Height	31006
2.904	+/-0.010	2.9001	✓		"	
0.735	+/-0.010	.735	✓		"	
0.500	+/-0.010	.500	✓		"	
2.00	+/-0.030	2.00	✓		vern	mmL-05
0.500	+/-0.010	.500	✓		Height	31006
Ø0.316	+0.006/-0.001	.316	✓		vern	mmL-05
Ø0.189	+0.005/-0.001	.189	✓		"	
R0.13	+/-0.030	.130	✓		RG	
0.70	+/-0.030	.700	✓		vern	mmL-05
1.000	+/-0.010	1.000	✓		Height	31006
1.500	+/-0.010	1.498	✓		vern	mmL-05
1.00	+/-0.030	1.00	✓		vern	mm
1.19	+/-0.030	1.190	✓			
2.125	+/-0.010	2.125	✓			
0.589	+/-0.010	0.585	✓			
R0.13	+/-0.030	.130	✓		RG	
1.270	+/-0.010	1.260	✓		vern	mmL-05
1.750	+/-0.010	1.750	✓			
7.500	+/-0.010	7.496	✓			
0.50	+/-0.030	.497	✓			

Measured by: mmL	Audited by: mf	Preliminary Approval:
Date: 18/04/21	Date: 18/04/24	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	11.04.05	Dimensions updated per Dwg Rev D	KJ	
C	11.06.21	Dimensions updated per Dwg Rev E	KJ	